

Work Order ID 89956

89956

Page 1

September-13-12 8:52:02 AM

Item ID: D4034-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Upper Rib Assembly

Start Date: 9/12/12 Start Qty: 1.00

1
1 (3X)

Cust Item ID:

Required Date: 9/12/12 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-09-13 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4034

B

100 Weld per dwg A/R S.S. rod Batch: 1122130 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

CC 12-11-20

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

(3) 12-11-21



120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

(3) 12-11-21



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Item ID: D4034-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Upper Rib Assembly
 Start Date: 9/12/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/12/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(3) CC 12-11-21
12/11/2011
MF 12-11-21

Picklist Print

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Work Order ID: 89956
 Parent Item: D4034-043
 Parent Item Name: Fwd Upper Rib Assembly

Start Date: 9/12/12

Required Date: 9/12/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC
 IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	32.0000	1	1		CC 12-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		-25							
				83755		1							
				86176		27			(3x)				
				87649		4							
				WA006		57							
D4034-5 Rib		Manufactured	No			100	Each	11.0000	1	1		CC 12-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		9		B 89285 →	(3x)				
				75656		1							
				87520		8							
				WA005		1							
				67339		1							
				WA006		1							
				82983		1							
D2327-3 Spacer Bushing		Manufactured	No			100	Each	4.0000	1	1		CC 17-11-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		4		B 88478 →	(2x)				
				75564		1							
				77229		1		B 89265 →	(1x)				
				81144		2		B 88561 →	(3x)				

Picklist Print

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Work Order ID: 89956

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 9/12/12

Required Date: 9/12/12

Start Qty: 1.00

Required Qty: 1.00

D4021-7 Manufactured No
Hoop

100 Each 7.0000 1 1 CC 12-11-20

Location

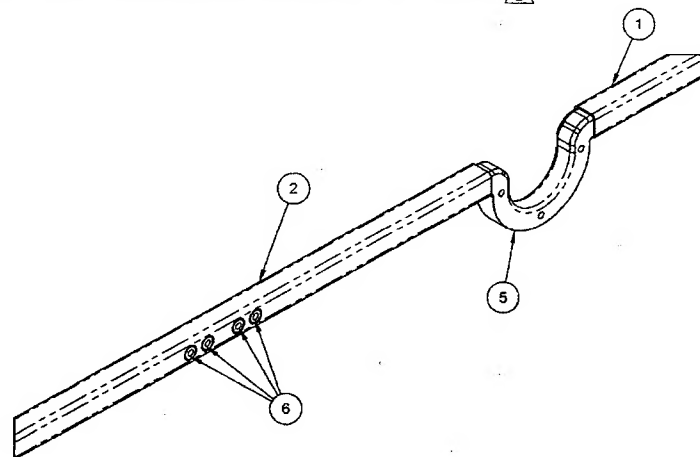
WA
56996
87487

Loc Qty

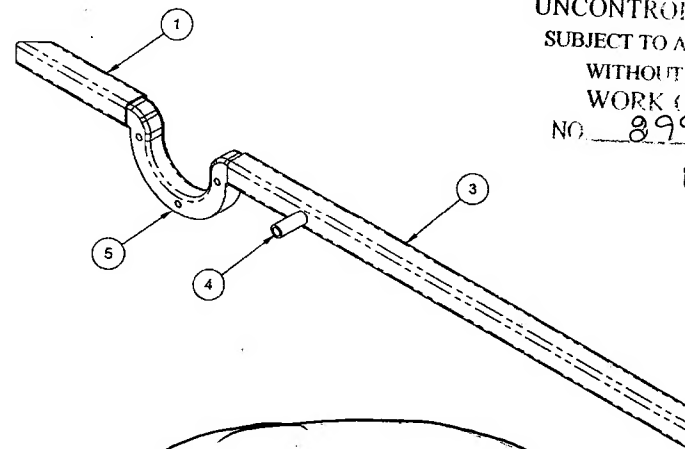
Loc Code

7 B 88428 → (2x)
0
7 B 89265 → (1x)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

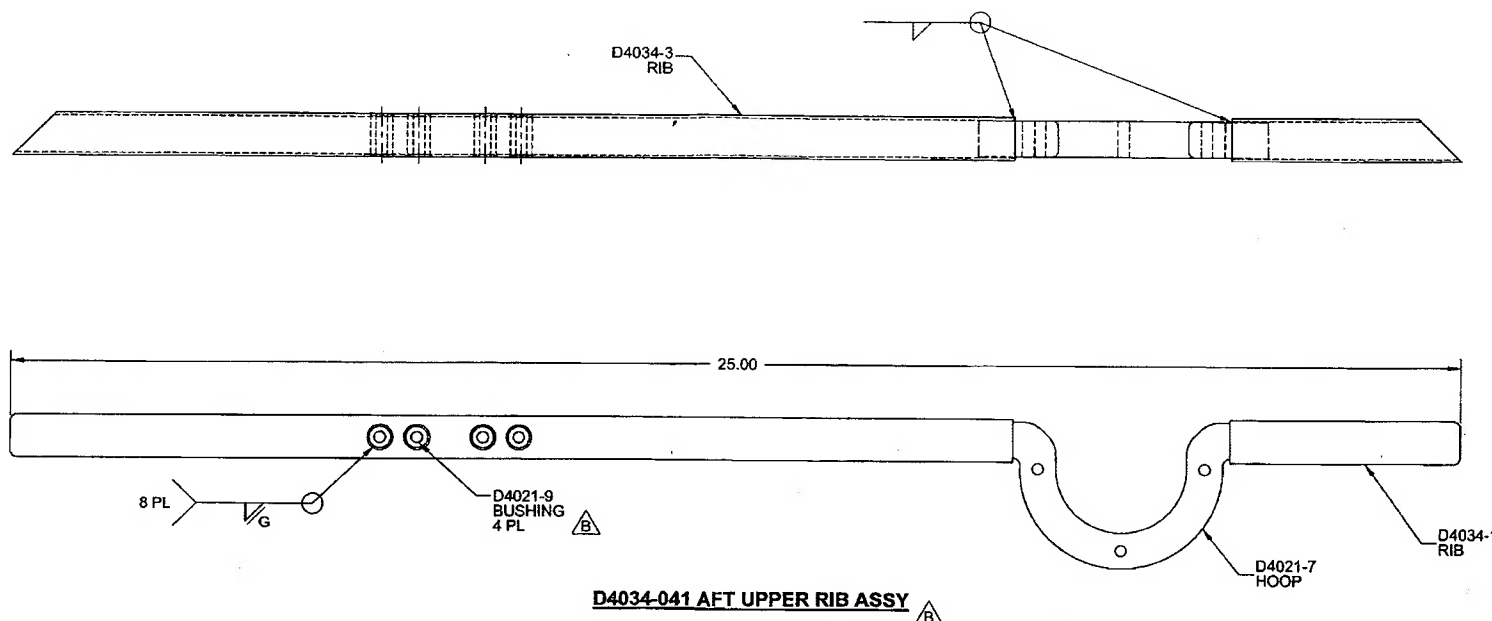
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 89956 MLJ
12-09-13

RELEASED
2011-01-18
JM

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	SC		
CHECKED	R		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	10.12.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4034	REV. B SHEET 1 OF 4
TITLE UPPER RIB ASSY, BASKET BASE	SCALE NTS
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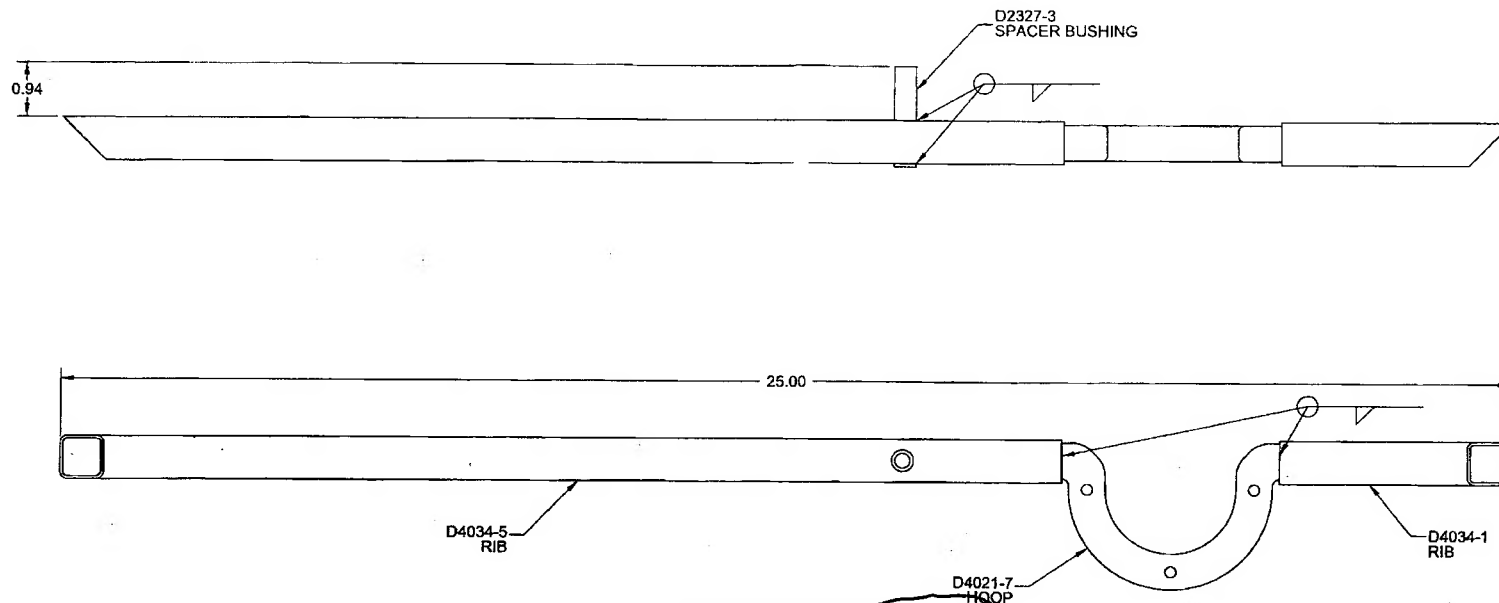
D4034-041 AFT UPPER RIB ASSY

RELEASED
2011-01-38

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AJS	D4034	SHEET 2 OF 4
APPROVED	WJD	TITLE	SCALE
DE APPR.	#	UPPER RIB ASSY, BASKET BASE	NTS
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D4034-043 FWD UPPER RIB ASSY

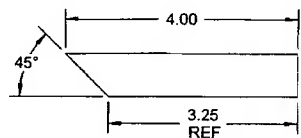
RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	IS	DRAWING NO. D4034	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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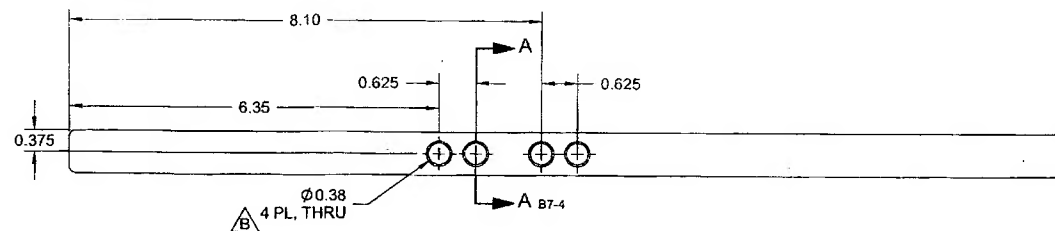


D4034-1 RIB

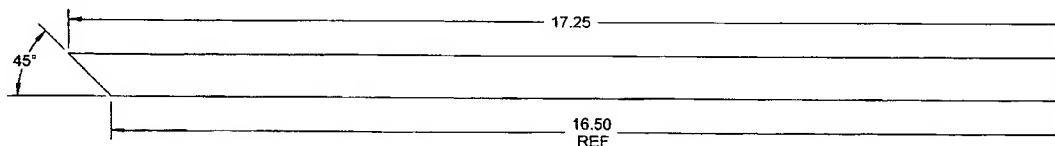
BREAK EDGE
0.030 X 45°
TYP



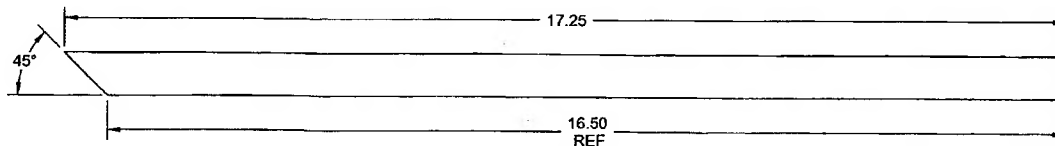
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	K	DRAWING NO.	REV. 8
MFG. APPR.		D4034	SHEET 4 OF 4
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2011-01-10

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